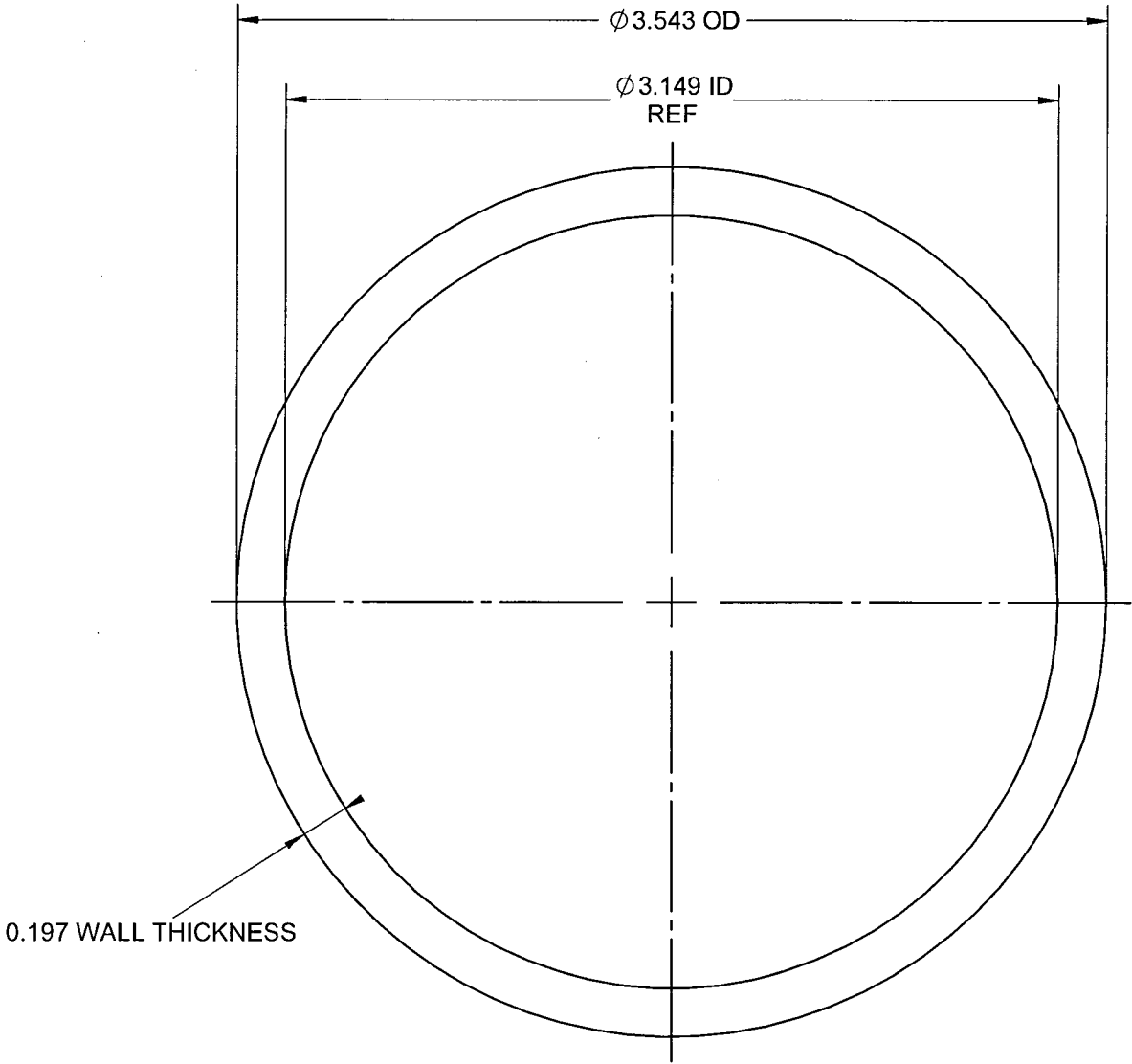


SPECIFICATION CONTROL DRAWING



D6027-XXX CROSSTUBE MATERIAL

WHERE XXX IS LENGTH IN INCHES
EG. 103" LONG TUBE: D6027-103

NOTES:

- 1) MATERIAL: 3.543 OD X 0.197 WALL 7075-T73/T73510/T73511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11 OR ASTM B210 OR ASTM B241) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 66 KSI
MINIMUM YIELD TENSILE STRENGTH = 56 KSI
MINIMUM ELONGATION = 12%
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO SENDING THE EXTRUSION TO AN OUTSIDE VENDOR
- 3) TOLERANCES: O.D.: +/- 0.008 MEAN (+/- 0.016 INCLUDING OVALITY)
WALL: +/-0.006 MEAN (+/- 0.019 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.500/-0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

C	UPDATED MATERIAL PROPERTIES, TOLERANCES AND ADD CHEMICAL CONVERSION COAT	ML	17.05.25
B	ADDED NOTE 9	ML	17.01.20
A	NEW ISSUE	ML	16.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	LL	D6027	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	CP	CROSSTUBE MATERIAL	NTS
DATE	17.05.25	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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APPROVED